

**Work Order ID 69422**

Tuesday, May 10, 2011 3:33:50 PM



Page 1

Item ID: D3258-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Bracket

Start Date: 5/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3258

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3258

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

Deburr if necessary

1311-5-11



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1311-5-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8-10-11

Counts

470

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69422**

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Item ID: D3258-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Bracket

Start Date: 5/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary ☐ Form as per Dwg D3258

SPS 1165112

20

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Subst 13

counts  
(20)

150



Packaging

Identify as per dwg &amp; Stock Location: 044

0.00

Memo

0.00

Packaging

P411012 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69422**

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Page 3

Item ID: D3258-1

Accept

Revision ID:

Item Name: Angle Bracket

Start Date: 5/10/2011 Start Qty: 6.00

Required Date: 5/16/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/13  
mf  
11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 10, 2011 3:33:59 PM

Page 1

Work Order ID: 69422

Parent Item: D3258-1

Parent Item Name: Angle Bracket





Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.11.01 Added Steps 6-7 KJ/JLM  
IPP Rev:C Now on Waterjet 06-12-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			110	sf	202.9000	0.005	0.031579		15	
											B 11-5-11		

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

202.9

117275

42.9

117653

160

117275

20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

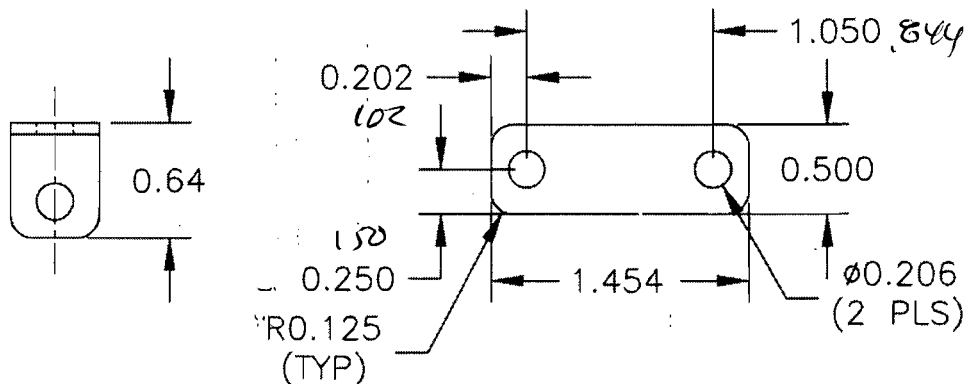
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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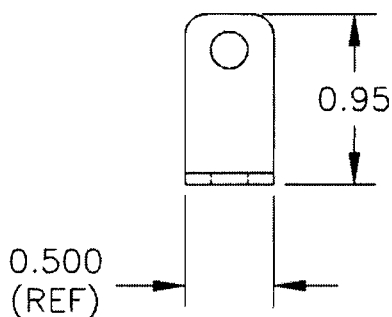


DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3258	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE ANGLE BRACKET	SCALE 1:1
A	04.01.27	NEW ISSUE	

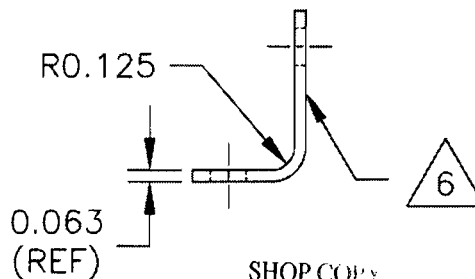
RELEASED  
04.04.05



**D3258-1 FLAT PATTERN**



**D3258-1 ANGLE BRACKET**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *09422*

**NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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